



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D4073-1 Job Sheet 189117



Part No: D4073-1

Job Qty: 20 pcs

Part Name: AW139 Door Hinge



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/18/19

Job Tracking No:

Due Date: 2/21/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV B SHEET 1 IPP REV:A NEW ISSUE 10-06-08 JLM VERIFIED BY:DD IPP REV:B DRAWING REV.
CHANGE AS PER ECN 11-598 11-07-05 JFS VERIFIED BY:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs		2/21/19	0.00	0.27	Bandsaw - 1		SBCL 19/02/12
105	HAAS 4 Axis - B4B	20 pcs		2/21/19	0.18	9.39	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBCL 19/02/12
							HAAS - 4 - B4B		
120	QC 8	20 pcs		2/21/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		Am 19/02/12
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
150	Handfinish - 1-1 Chemical-B4B	20 pcs		2/21/19	0.00	0.42	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 -		



Container No: S152633



Part: D4073-1

Job No: 189117

Serial No/Batch: S152633

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 02/12/19

Plex 1/18/19 11:14 AM Dart.Macdonald.Dara

					B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/2/13
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	Powdercoat - 1 White G(A)- B4B	20 pcs	2/21/19	0.00 0.33	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
	START: 8:00 O.V.F: 3:30 FINISH: 8:30					BL 19.02.21
170	QC 3	20 pcs	2/21/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 38	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	

				QC 3 - 68	DAS 40	DAS 9
				QC 3 - 9	9-89	9-89
180	Packaging 3-1 - Stock - B4B	20 pcs	2/21/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	ST073 97 FEB 26 2019
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190	QC 21 - SA	20 pcs	2/21/19	0.00 0.00	QC 21 - SA - 21	DAS 21 FEB 26 2019
					QC 21 - SA - 70	9-89

Part Op 100 - (Bandsaw) cut blank 4.563" long
 Descriptions: 105 - (HAAS CNC Vertical Machine) Mill as per Dwg an Folio FA939
 120 - (QC8- Inspect parts - second check)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)
 170 - (QC3- Inspect Part Finish)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X01.250	6061-T6 Bar 2.00 X 1.25	7.6000 ft (.38 ea)	100-Bandsaw - 1	SL27979

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.000X01.250	8	30	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Hinge	0.130Inches ± 0.030	0.160 0.100	Radius	125
2	Door Hinge	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	205
3	Door Hinge	2.000Inches ± 0.030	2.030 1.970		2,000
4	Door Hinge	0.810Inches ± 0.030	0.840 0.780		806
5	Door Hinge	0.350Inches ± 0.010	0.360 0.340		349
6	Door Hinge	1.100Inches ± 0.010	1.110 1.090		1,100
7	Door Hinge	0.500Inches ± 0.010	0.510 0.490	Diameter	502
8	Door Hinge	0.125Inches ± 0.010	0.135 0.115		125
9	Door Hinge	0.340Inches ± 0.010	0.350 0.330		340
10	Door Hinge	1.320Inches ± 0.010	1.330 1.310		1,320
11	Door Hinge	4.440Inches ± 0.030	4.470 4.410		4,436
12	Door Hinge	4.130Inches ± 0.030	4.160 4.100		4,125
13	Door Hinge	0.310Inches ± 0.030	0.340 0.280	Radius	310
14	Door Hinge	0.313Inches ± 0.010	0.323 0.303		313
15	Door Hinge	0.630Inches ± 0.030	0.660 0.600		624
16	Door Hinge	1.000Inches ± 0.030	1.030 0.970		377 1,000
17	Door Hinge	0.380Inches ± 0.030	0.410 0.350		377
18	Door Hinge	0.190Inches ± 0.010	0.200 0.180		191
19	Door Hinge	1.800Inches ± 0.030	1.830 1.770		1,801
20	Door Hinge	0.250Inches ± 0.030	0.280 0.220		248
21	Door Hinge	0.130Inches ± 0.030	0.160 0.100	Radius	130

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68-6
LS
SXD

DAS
57
9-89

19/00/12